Work Orde May-29-12 2:50	er ID 84902 0:06 PM	•		*849	302*					· · · · · · · · · · · · · · · · · · ·	Page
Item ID: Révision ID:	D209-669-043		A	Accept	*N900	040	100)*	Setup Star	* *N	S1*
Item Name:	Replacement Skidtube								Stop	° *N	S2*
Start Date: Required Date:	_	ty: 1.00 Qty: 1.00	*1* *1*		Cust Item Customer:						
Reference:			•	•					•		
Approvals:	Process Plan:ML		ate: 12/05/29	Tooling: SPC (Y/N):		ate:	-]	Run Star Stop		R1*
C. ID/				-							RZ
Sequence ID/ Work Center II	Operation Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		· · · · · · · · · · · · · · · · · · ·		·						
D2906	Rev B	1									,
100			~	0.00	· · · · · · · · · · · · · · · · · · ·					$-i\Delta$	
100	DOCUME	NT CONTROL					1	,	NA	19X1	
Document Control		Memo Photocopy D209-	669 bluefile & type labe	0.00 els per PPP D205-669-0	043 Chg 602 PEF	ZCN12-S	99 ~				
110											
110	Skidtubes			0.00							
Skidtubes		Memo		0.00					 		. <u> </u>
Skidtubes		- Inspect mat'l D2	2500-1-190 for damage			CF	12	6.12			
		-Drill pilot holes u	ısing drill jig DT8149, I	DT8711-2 & DT8711-3	3 (Do not use	O,	·				
		-Open holes to 0.5	500" as per Dwg D2906	without cutting fluid							
		-Deburr and blow	out all chips from		\ <	AD	12	06-18	>		
		-Acid etch and Al	odine tube per QSI 005	4.1		7 / 7	101-	Ce. /(_		

Dart Aerospace

w/o: ಳ	4902	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	<u> </u>			<u></u>			

Part No: <u>D 209-669-043</u>	PAR #: Fault Catego	ory: <u>Xid Lube</u>	NCR: Yes No	DQA:	Date: 17	407/19	9
Resolution:	Disposition:	ory: Didtube	QA: N/C Closed	:_Q	Date: _i	2/7	1

NCR: 12	1683/	W	ORK OR	DER NON-CONFORMANCE	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
(7/6/18	140	Tubes are overbant. 2.350 Flud, 1.665 att.	17/4/18	Acceptable TERM FWD END 0.1"-0.175"	12-18	St. pob 18	12/6/18	7/06/19
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Work O	raer ID	8490
May-29-12	2:50:06 PM	

May-29-12 2:5	•			*849	4()ク*						Page 2
Item ID: Revision ID:	D209-669-0			Accept	*N900	040	100)* s	Setup Star	17.7	\$1 *
Item Name: Start Date: Required Date: Reference:	Replacement 29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item :		******		Sto	, *M2	\$ 2*
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		F	Run Star	"INF	₹1*
	QC:		Date:	_ SPC (Y/N):	D	ate:			Sto	*NF	? 2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	0	Operation Description C3- Inspect Part Finish C7 Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Number	Insp. Stamp O 6-/2
130 *120* Skidtubes	•	Skidtubes Memo		0.00				- OC_	12/06/	(1 <u>2</u>	
Skidtubes		Pick: Qty Part Nui A/R Sikafl	mber Description Batch lex-291 $\frac{i21/0.9}{6.00}$ Date: $i2.2$	66/12	e cutting					e e	

description Web

B/N 84950

pick: Qty 1

P/N D2926-3

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Ŵ/O:		WORK ORD	ER CHANGES			
DATE	STEP	PROCEDURE CHANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr Approval Occlinspector
12-06-12	120	change acz 60 Gcz				

Part No:		_ PAR #:	Fault Category:	N	CR: Yes No. D	QA:	ate:
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	Resolution:		Disposition:	Q	A: N/C Closed:	Headail D	ate:

NCR:			WORK O	RDER NON-CONFORMANCE	E (NCH)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approvel
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section ©	Chief Eng	Approval QC Inspector

Skidtubes

-Deburr ends and remove markes from bending

- Insert D4202-1 spacer, swage as per QS1002 and trim/ grind flush per QS1002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expantion and finish with 1/2 x 18G to achieve dwg dimention.

160 QC5- Inspect part completeness to step on W/O

Memo

Insp.

Page 3

160 OC

Quality Control

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W/O:	-		WC	ORK ORDER CHANG	GES					
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Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQ	\:	_ Date: _	
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DATE	STEP	Description of NC			ction B	Oima e	Verific		Approval	Approval
	012	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Ord <i>May-29-12 2:50</i>		902		*849	302*							Page	4
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D209-669-0-Replacement 29/05/2012 16/07/2012		*1* *1*	Accept	*N900 Cust Item 1 Customer:	ID:	100) *	Setup	Start Stop	1/1	S1* S2*	
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:	·-·		Run	Start Stop	171	R1* R2*	
Sequence ID/ Work Center II 170 *170* Skidtubes Skidtubes)	Operation Description Large Fab Memo -Drill holes not to hit w	for wearplates using DT8. eb.Deburr	Set Up/ Run Hours 0.00 0.00 217 Open holes to 19/64",	Tool ID	Tool#	Plan Code	Accep Qty	et Re Qt		Reject Number	Insp. Stamp	

190

QC5- Inspect part completeness to step on W/O

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburt

190

Quality Control

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Dart Aerospace Ltd

W/O:			WC	RK ORDER CHAN	GES		· · · · · ·		
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	s No DQ	A:	Date:	
	Res	solution:	Dispositio	n: :	QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORM	MANCE (NC	:R)			
DATE	STEP	Description of NC	<u> </u>		ection B	Verific	ation	Approval	Approval
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Work Ord <i>May-29-12 2::</i>		902		*849	302*					Page
Item ID: Revision ID: Item Name:	D209-669-0 Replacement		···································	Accept	*N900	04 0	1100)* s	Setup Start Stop	*NS1*
Start Date: Required Date Reference:	29/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			·	"N.S./"
Approvals:		in:		0 _	Da	- · · ate:		R	tun Start Stop	*NR1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NR2*
Sequence ID/ Work Center 1	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp
200		Pressure Wash per QSI00	05 4.3	0.00					1	
200 HandFinish Hand Finishing		Мето		0.00					_W6	12-76
210		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00				111.	2/	M
210 Powdercoat Powder Coating	04	Memo START TIM OVEN TEM FINISH TIM	PERATURE:) 2007				LX J	<i>/</i>	
√ ('d. (D (QC3- Inspect Part Finish	75-30	0.00						
220		Memo		0.00					X(DD 124
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Quality Control

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W/O:			WORK ORDER	CHANGES				
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Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	Resolution	•	Disposition:	QA: N/C	Closed:	* .	Date: _	·

NCR:			WORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Orde May-29-12 2:50):06 PM	902		*849	902*				·=			Page 6
Revision ID:	D209-669-04	13		Accept	*N900	040	100) *	Setup	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:					14	
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	- ·		Run	Start Stop		R1* R2*
Sequence ID/ Work Center ID 230)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
230 HandFinish Hand Finishing		HandFinishing Memo		0.00 Dwg. D2906. Use a drop of					8		DP)	12/07/00

Hand Finishing

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 130 Sikaflex expire date: 14/63

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 121138 Sikaflex expire date: 14/63

5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch: 122 320

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W/O:			WORK ORDER	CHANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category:	NCR: Ye	s No D O	A:	Date: _	
	Re	solution:	Disposition:	QA: N/C	Closed: _		Date: _	
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NCR:			WORK ORD	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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l								

Page 7 May-29-12 2:50:06 PM Item ID: D209-669-043 Accept *N900040100* Setup Start Revision ID: Item Name: Replacement Skidtube **Start Date:** Start Qty: 1.00 29/05/2012 **Cust Item ID:** Req'd Qty: 1.00 **Required Date:** 16/07/2012 **Customer:** Reference: Run Process Plan: Approvals: Date: _____ Tooling: Date: Stop Date: _____ OC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp 240 QC5- Inspect part completeness to step on W/O 0.00 *240* とうしかい OC Quality Control Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 250 0.00 Packaging *750* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPPD209-669-043 Location: PPP Rev: 260 QC21- Final Inspection - Work Order Release 0.00 mr 120118 0.00 Memo Quality Control

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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Picklist Print

May-29-12 '2:50:10 PM

Work Order ID: 84902

84902

Parent Item:

D209-669-043

D209-669-043

Parent Item Name:

Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by: EC

1.	PP Rev:B remove	DT # in seq140 1	DD 10.	.03.10 Veriti	ed by:EC								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1	٥	Manufactured	No				Each	81.0000		19		, (
D4202-1	•				B84763				**	(19)	DC 12,	107/05	
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code	No.				
				LG			5		<u> </u>		_		
					77727		5		_		_		
				LG002	70006		76				_		
					78806 79810		6 70		_				
D2500-1-190		Manufactured	No		7,7010	110	Each	91.0000	1	1	_		
D2500-1- Ext'n - I' Beam Tube 4"	190	Translature Ca	•				S	71.0000	**	1	CF	12.6	12
				Location	1	Loc	<u>Oty</u>	Loc Code					
				HALL			91				_		
					74777		14		_		_		
D2926-3		Manufactured	No		80061	110	77	0.0000			_		
		Manufactured	190	_	_	110	Each	0.0000	1	1	/		
D2926-3									**) De	- 12/06	12	
D2855		Manufactured	No	B849	· ~	230	Each	21 0000	_	_	·	, -	
		Manufactured	INO	2011	30	230	Each	21.0000	2	2			
D2855									**	2	(20)	12/	07/09
•	. \ 1			Location	1 ,	Loc	<u>Qty</u>	Loc Code					
				FP002	84952/		21				_		
	1XX				65519		2						
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75074

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Part No	:	PAR #:	Fault Cated	jory:	NCR: Yes	No DQ	A:	Date:						
	Re	solution:	Disposition	n: '	QA: N/C Cld	osed:		Date: _	<u>-</u> `					
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NCR)								
DATE	STEP	Description of NC		tion B	Verific	ation	Approval	Approval						
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Work Order ID: 84902

Parent Item:

AN3-5A

D209-669-043

Parent Item Name: Replacement Skidtube

84902 *D209-669-043*

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Location Loc Oty Loc Code ST350 1090 115371 46 117423 124 118626 31 119355 200 120187 500 121185 189 230 Each 0.0000

230

No

No

No

*AN960.JD101 *

ALS7-1032-130

Washer

ALS7-1032-130

AN960JD10L

Purchased

Purchased

12(01/

230 Each

Each

2,136.000

1.090.000

12/07/09

**

NAS1149D03321 Purchased

<u>Locatio</u>	<u>n</u>	Loc Qty	Loc Code	
ST280	1212691	51		
	117717	27		
	118966	22		
	119775	2		
ST282		2085		
	119530	73		
	120181	12		
	121444	2000		

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANGE	ES									
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Resolu		olution:	Disposition): <u>'</u>	_ QA: N/C CI	osed:		Date: _						
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5475		Description of NC Section A		Corrective Action Section		Verific	cation	Approval	Approval					
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May-29-12 2:50:10 PM Work Order ID: 84902

84902

Parent Item:

D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

Manufactured

Each

1,458.000

Loc Code

0.0000

**

Page 3

AN3C4A

Locatio	"122151 V		Loc Qty
ST350	12231		1458
	120187		57
	120521		28
	120769		38
	121205		1000
	121556	٠,	335
		230	Each

230

AN960C10L

washer

NAS1149C0332 Purchased

No

No

**

D2594-3 *D2594-3*

*AN960C101 *

O-Ring, 205 Skidtube

22063

230 Each 2,418.000

<u>Location</u>	Loc Oty	Loc Code	
FP001	2418		
65518	41		
79496	984		
79573	50		
79755	1343		

W/O:	/O:			ORK ORDER CHANG	ES							
DATE	STEP	PRO	CEDURE CH	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Work Order ID: 84902 Parent Item: D209-669-043 Parent Item Name: Replacement Skidtube			*84902* *D209-669-043*				rt Date: 2	9/05/2012	Required Date: 16/07/2012 Required Qty: 1.00		
*D2594-1 *D2594-1* Plug, 205 Skidtube	Manufactured	No		230 E	Each	311.0000	14 **	14 1 4		(2/07/04	
D3564-9 *D3564-9* Wearshoe	Manufactured	No	Location FP001 73401 74442 79495 FP-A 73401 78590	Loc Oty 98 30 18 50 213 0 213 230 E) 	22.0000 Loc Code	 **			12/07/09.	
D3564-11 *D3564-11* Wearshoe	Manufactured	No	FG 84870 76950 FP001 67590 69943 82255	4 4 18 4 1 13		8.0000	 **	1		12/67/09	
			FG 848H	4					_		

FP001

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W/O:			W	ORK ORDER CHANG	ES			
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					* **			
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DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval
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Work Order ID: 84902 *84902* Parent Item: D209-669-043 *D209-669-043* Parent Item Name: Replacement Skidtube **Start Date:** 29/05/2012 **Required Date:** 16/07/2012 Start Qty: 1.00 Required Qty: 1.00 D3564-5 Manufactured 230 Each 13.0000 ** Wearshoe Location Loc Qty Loc Code FG 2 34806 FP001 11 77609 3 82254 8 D3566-1 Manufactured No 230 Each 31.0000 *D3566-1* ** Gasket Location Loc Qty Loc Code -22 81619 10

FP002 53
68924 2
80919 3
83898 16
230 Each 21.0000 1 1

D3566-5

Manufactured

D3566-5

 Location
 Loc Qty
 Loc Code

 FP
 \$\frac{1}{2}\$
 12

 82275
 12

 FP002
 9

 80374
 3

 82274
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Dart Aerospa	ce Ltd
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RETURN TO **ENGINEERING**

- ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

ADA REV. E SHEET 1 OF	HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2906 SHE	2	J@ &	ED PR.	DRAWN CHECKED MFG. APPR.
T P	DART AEROSPACE LTD		b		DESIGN
04.06.22 DATE	DESCRIPTION BY	OE	SOUE	N N N	A REV.
07.08.21	ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES; NEW ISSUE	SS STEE RPLATE TE 10; OVE AFT RECTED ACES W	ADD STAINLESS STECHANGE WEARPLATED TO 1: ADD NOTE 10; PG 2 C7: REMOVE AIR 3 CORRECTE PG 3 D7: 38 PLACES NEW ISSUE	ADD STAINL CHANGE WI PG 1: ADD N PG 2 C7: RE PG 3 C3: C0 PG 3 D7: 38	ω <

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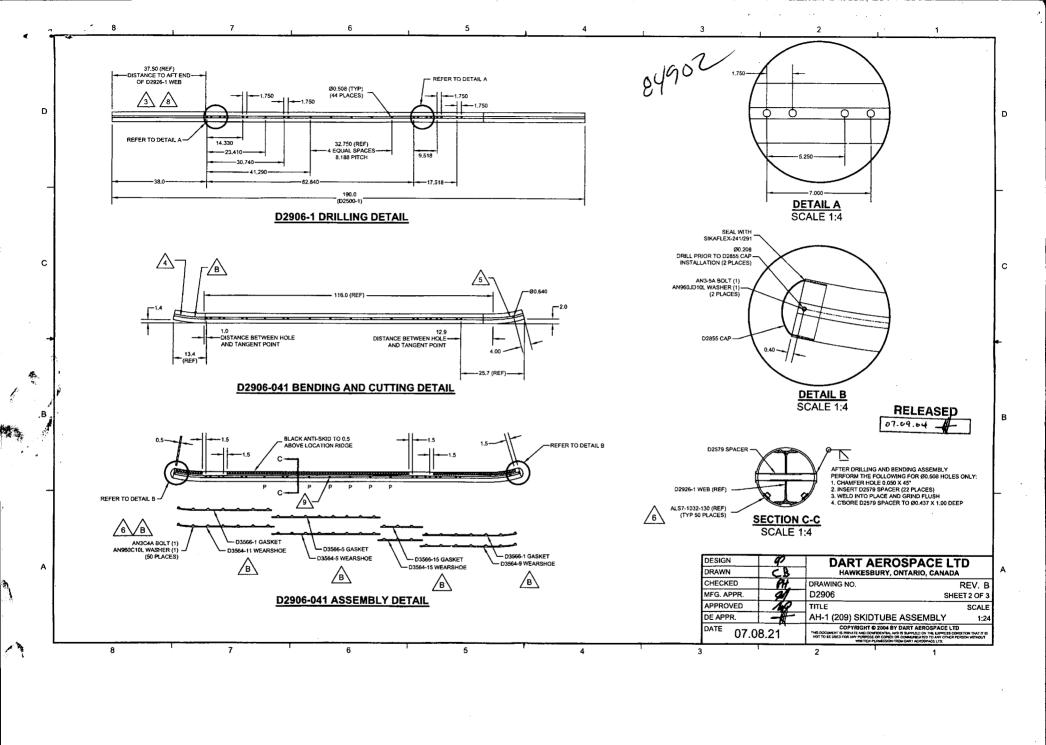
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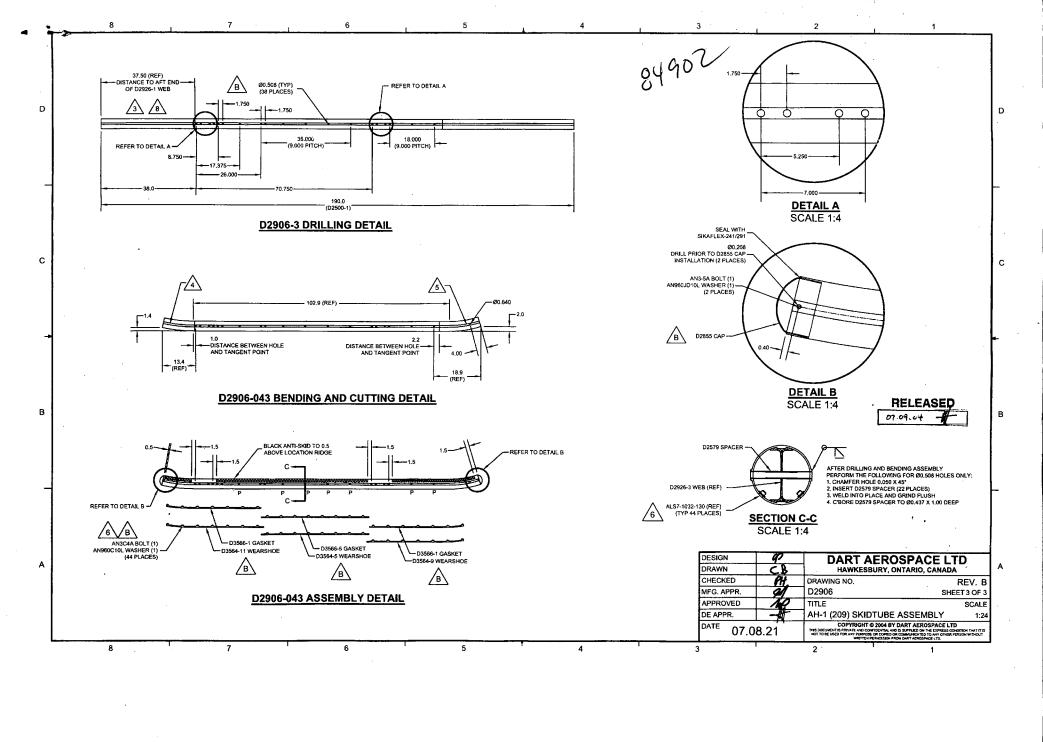
Dart Aerospace Ltd

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